



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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SWA3-100
Job Sheet 183079



DL-S #5
912

Part No: SWA3-100

Job Qty: 10 ea

Part Name: Upper End - Swa3 Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-100 Rev 15 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	10/12/18	10/12/18	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	10/12/18	10/12/18	0.00	10.00	MORI NLX		
120	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2		
130	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC8		
140	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 6.250"

Descriptions: 110 - 1-Machine as per DWG. FC330 FOLIO REV: 15 DWG REV: 15 2-Deburr ***Machine engrave S/N number and machine engrave UP arrow***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.000	17-4 SS Round Bar 2.000"	5.2000 ft (.52 ea)	90-Start up Operation	5120116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R2.000	5	1	0

Part Specifications

Specifications could not be found.



Container No: S128892



Part: SWA3-100

Job No: 183079

Serial No/Batch: S128892

Revision: 15

Inspector:

Exp Date:

Instructions:

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Printed 9/12/18 10:04 AM Dart.lajeunesse.marie

Date: 11/19/18

DQA: _____ Date: _____



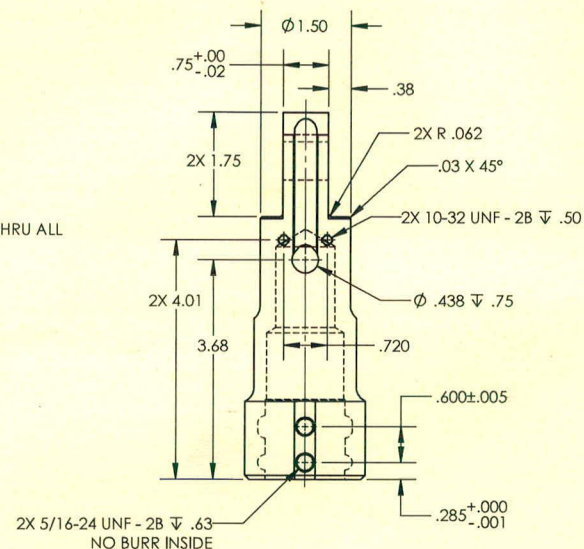
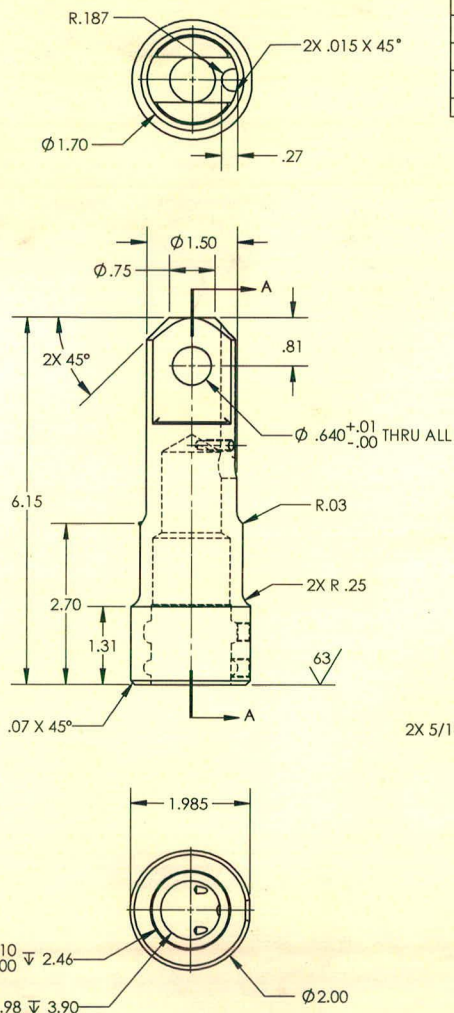
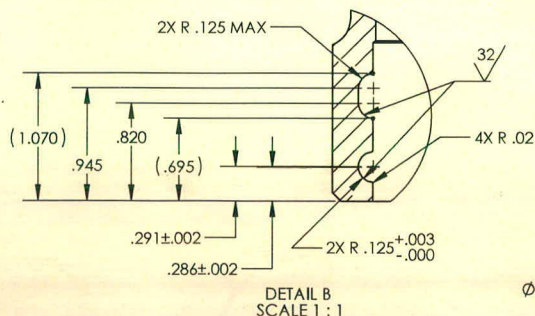
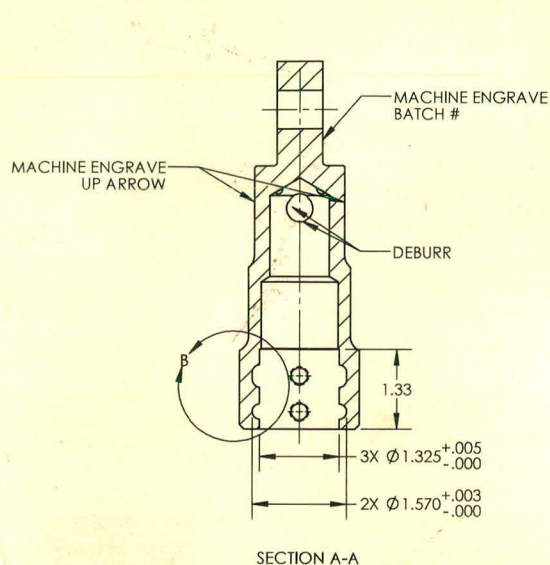
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVE
11		AS DRAWN BY CANAM			8/24/2012		
11A		CHD DIMENSIONS 1.070 & .695 TO REFERENCE, ADDED CENTER DIMENSIONS OF .945 & .820			11/15/2012	JAG	
12	15-0270	ADDED UP ARROW NOTE, CHD MATL WAS S.S 17-4 PH IS S.S 17-4, H1150/1075, CHD DIM WAS .75 IS .75 +.00 -.02.			9/22/2015	DPD	JAG
13	16-0083	CHD DIM WAS .375 IS .38, WAS .286 IS .286 ± .002, WAS .291 IS .291 ± .002, WAS Ø 1.325 ± .005/-0.000 IS 3X Ø 1.325 ± .005/-0.000, WAS Ø 1.570 ± .003/-0.000 IS 2X Ø 1.570 ± .003/-0.000.			7/18/2016	SM	JAG
14	17-0036	CHD DIMS WAS 1.75 IS 2X 1.75, WAS 2X 5/16-24 UNF - 2B .63 NO BURR INSIDE, WAS 4X R.015 IS 4X .02, ADDED NOTE MACHINE ENGRAVE BATCH #.			2/6/2017	RJC	JAG
15	17-0153	CHD DIM WAS Ø 1.00 ± .010/-0.000 .3.90 IS Ø .98 ± .003/-0.000.			6/20/2017	RJC	JAG

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183079 MWS
180912

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA3-100	1	UPPER END	S.S. 17-4, H1150/H1075	

DART AEROSPACE	
TITLE UPPER END SWA3 SWIVEL	
DWG NO. SWA3-100	REV 15
MATERIAL S.S. 17-4, H1150/H1075	
TREAT FINISH SPEC	
DRAWN BY: CANAM	
CHECKED: DUERFELDT	
CAPP APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 6/18/2002
SHEET 1 OF 1	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ± 1/8
ANGLES ± 5°
SURFACES ± 125
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL

DART AEROSPACE LTD		Work Order:	183079
Description: upper end SWA3 Swivel		Part Number:	SW43-100
Inspection Dwg: SW43-100		Rev: 15	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.33	$\pm .01$	1.322	✓		Vern LPID	
Ø 1.325	$+ .005 / - .000$	1.329				
Ø 1.570	$+ .003 / - .000$	1.5715				
R.187	$\pm .005$	.187			Rad gauge	
.015 x 45°	$\pm .005 \times .5^\circ$	.015 x 45°			Vern LPID	
.27	$\pm .01$	.273			HG	
Ø 1.70	$\pm .01$	1.698			Vern LPID	
Ø 1.50	$\pm .01$	1.498				
Ø .75	$\pm .01$	.75				
45°	$\pm .5^\circ$	45°				
6.15	$\pm .01$	6.152				
2.70	$\pm .01$	2.700				
1.31	$\pm .01$	1.313				
R.25	$\pm .01$	.250				
R.03	$\pm .01$	.032				
Ø .640	$+ .01 / - .000$	.643				
.81	$\pm .01$	.809				
1.985	$\pm .005$	1.980				
1.28	$\pm .01 / - .00$	1.285				
Ø .98	$\pm .01$	.990				
2.46	$\pm .01$	2.465				
3.90	$\pm .01$	3.905				
Ø 2.00	$\pm .01$	1.990				
Ø 1.50	$\pm .01$	1.499				
.75	$\pm .00 / - .02$	.740				
1.75	$\pm .01$	1.753				
4.01	$\pm .01$	4.008				
3.68	$\pm .01$	3.675			HG	
.285	$\pm .000 / .001$	.285				

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18-11-27	Date:	18/11/28	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

